

Date: Thursday, 6/7/2007 3:30:07 PM
 User: Kim Johnston

Process Sheet

8/2/07
 83 07/10/23

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEB ASSEMBLY
 Job Number : 32856~(Part Number : D2174041
 Estimate Number : 10194 Drawing Number : D2174 REV E
 P.O. Number : Project Number : N/A
 This Issue : 6/7/2007 S.O. No. : Drawing Revision : E
 Prsht Rev. : NC Material :
 First Issue : 1/1 Type : SMALL / MED FAB Due Date : 6/30/2007 Qty: 20 Um: Each
 Previous Run : 31651
 Written By :
 Checked & Approved By : 07.06.08
 Comment : Est: D 04.06.10 Reformat; Changed Step 2 KJ/JLM
 Est Rev:E As per Rev E 06-11-22 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D21741 Web



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)
 Web

Qty Part Number Description Batch
 1 D2174-1 Web ~~B321603~~ B 35503 mf

2.0 D21751 Angle LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)
 Angle LH

Qty Part Number Description Batch
 1 D2175-1 Angle B 32570 mf

3.0 D21752 Angle RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)
 Angle RH

Qty Part Number Description Batch
 1 D2175-2 Angle B 35342 mf

4.0 MS20470AD46 Rivet, Universal Head



Comment: Qty.: 19.0000 Each(s)/Unit Total : 380.0000 Each(s)
 Rivet, Universal Head

Qty Part Number Description Batch
 19 MS20470AD4-6 Rivet M105408 x 306mx, m104118 x 74mx.
~~M104118~~

mf 07-11-02

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/10/23		Split into M/A No Split did on 1 w/o	SB	07/10/23	17		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 6/7/2007 3:30:07 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEB ASSEMBLY

Job Number: 32856

Part Number: D2174041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per Dwg D2174-041

2- Identify as D2174-041

mf 07-11-02

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 Alulor

count

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m-l 07/11/

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

MS

07-11-05

20x

9.0

AN526C832R14

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 80.0000 Each(s)

Screw

Batch: M9216

18

07/11/05

10.0

AN960JD8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 80.0000 Each(s)

Washer

Batch: M104625

18

07/11/05

11.0

MS21042L08

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 80.0000 Each(s)

Nut

Batch: M105430

18

07/11/05

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install nuts & bolts loosely as per Dwg D2274

07/11/06 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 6/7/2007 3:30:07 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEB ASSEMBLY

Job Number: 32856

Part Number: D2174041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC5

INSPECT WORK TO CURRENT STEP



06.11.07

Comment: INSPECT WORK TO CURRENT STEP

7/11/06 (x20)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

6/7/11/06 (x20)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



07.11.07

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



6/07.11.07

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

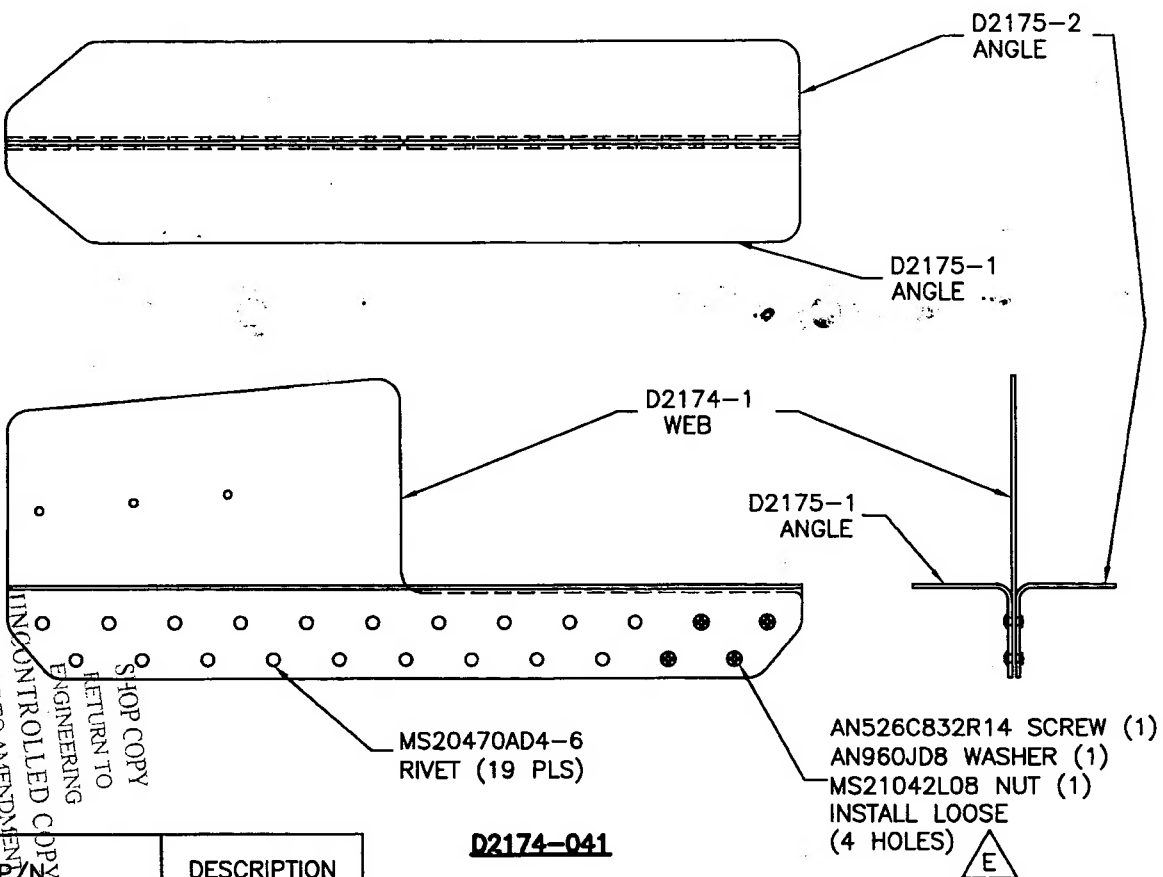
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
RF	CE		
CHECKED PH	APPROVED CH	DRAWING NO. D2174	REV. E
DATE 06.09.25		TITLE WEB ASSEMBLY	SHEET 1 OF 2
			SCALE 1:3
A	95.10.25	NEW ISSUE	
B	96.01.18	RE-DRAWN	
C	00.09.11	UPDATE FINISH SPEC.	
D	04.06.03	RE-DESIGN	
E	06.09.25	INC 4 HOLES TO Ø0.172: CHG HARDWARE	



D2174-041

QTY	P/N	DESCRIPTION
X	D2174-041	WEB ASSEMBLY
1	D2174-1	WEB
1	D2175-2	ANGLE
1	D2175-1	ANGLE
4	AN526C832R14	SCREW
4	AN960JD8	WASHER
4	MS21042L08	NUT
19	MS20470AD4-6	RIVET

NOTES:

- 1) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) IDENTIFY WITH P/N D2174-041 USING FIND POINT PERMANENT INK MARKER.

RELEASED
06.10.13

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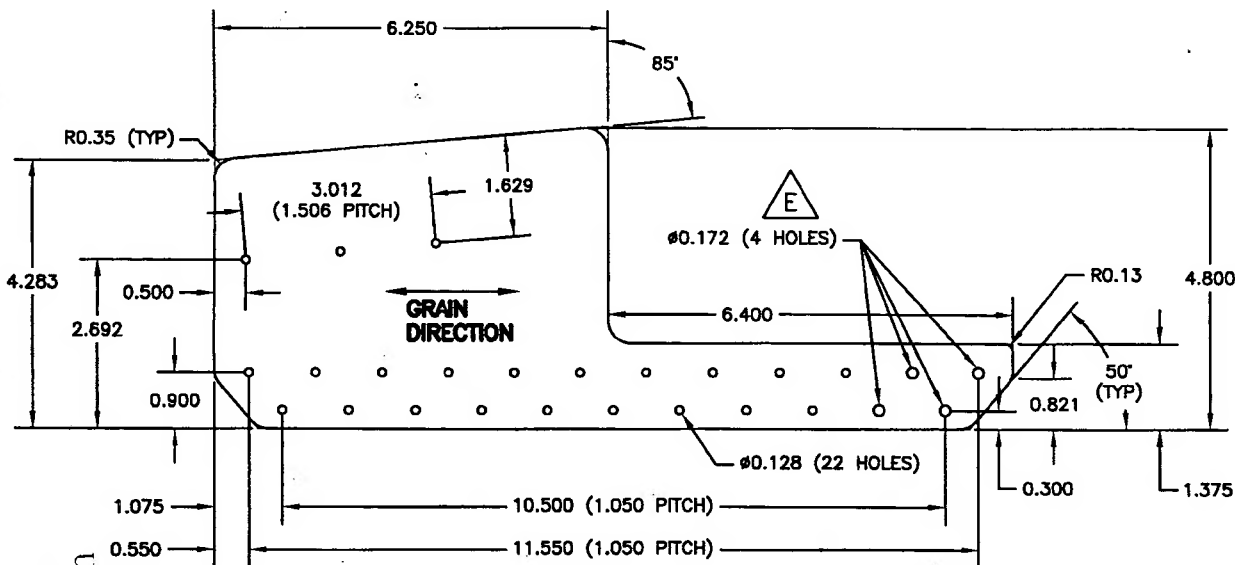
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DESIGN	DRAWN BY	DART AEROSPACE LTD
RF	CE	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
PH	[Signature]	D2174
DATE	TITLE	REV. E
06.09.25	WEB	SHEET 2 OF 2
		SCALE
		1:3

RELEASED
06.10.23



D2174-1

NOTES:

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-200/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) ALL DIMENSION ARE IN INCHES

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NO.

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